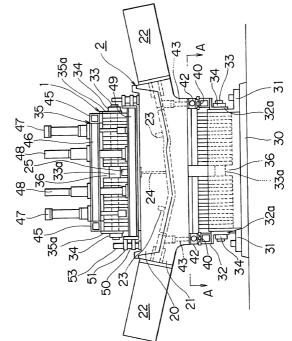
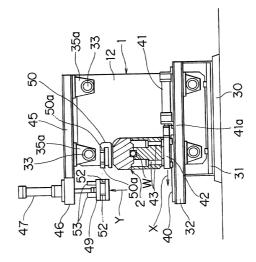
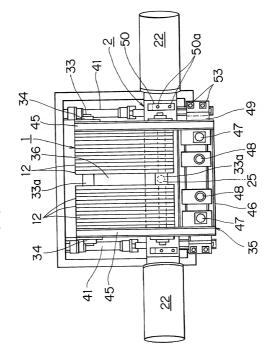
F1G.1



F I G.2



F1 G. 3



F I G. 4

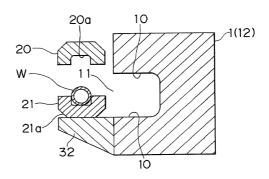
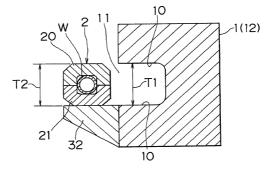
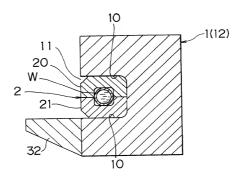


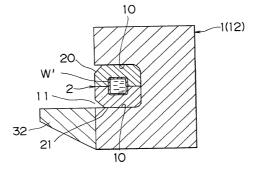
FIG. 5



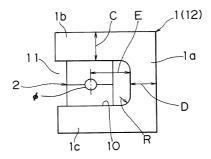
F1G.6



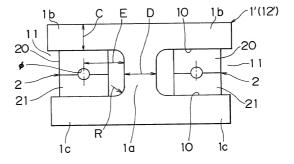
F I G. 7



F I G. 8

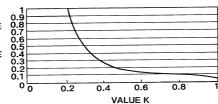


F I G. 9

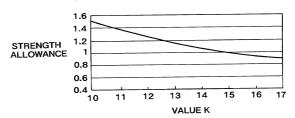


F I G. 10A

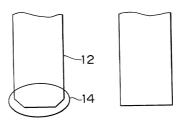
EQUIPMENT VOLUME RATIO BY COMPARISON WITH CONVENTIONAL ONE



F I G. 10B



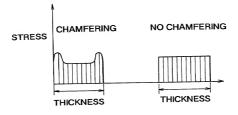
F I G. 11



STEEL PLATE CHAMFERED FOR USE IN INVENTION

NON-CHAMFERED STEEL PLATE

F I G. 12



F I G. 13

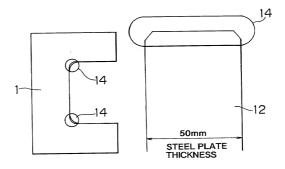
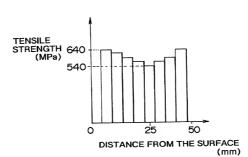


FIG. 14



F I G. 15

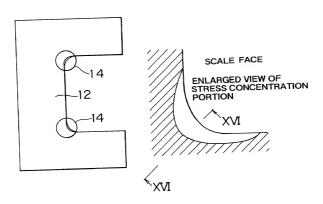
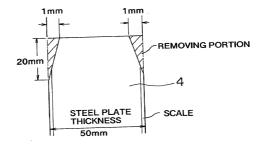
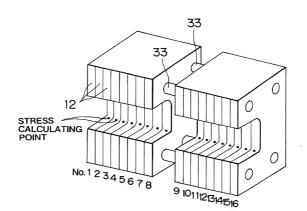
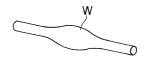


FIG.16



F I G. 17





F I G. 18

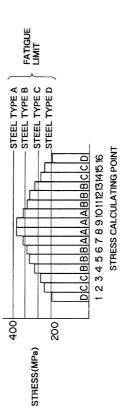
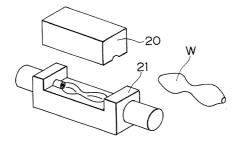


FIG.19



F I G. 20

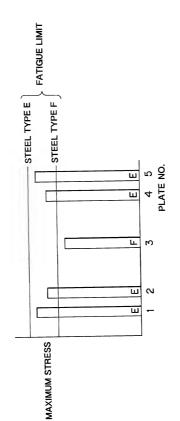


FIG. 21

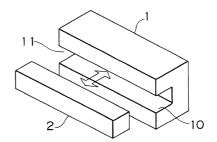
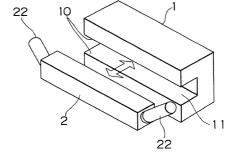
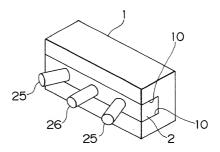


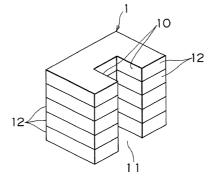
FIG. 22



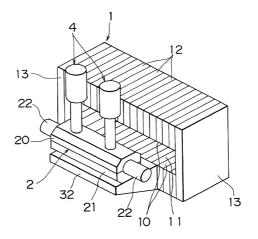
F I G. 23



F I G. 24



F I G. 27



F I G. 25

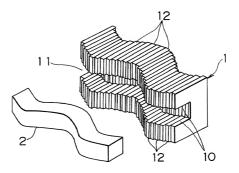


FIG. 26

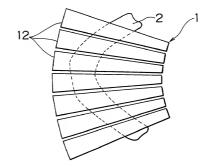


FIG. 28

41

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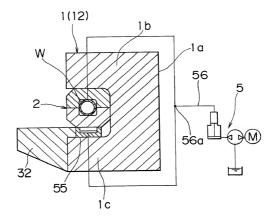
66

4

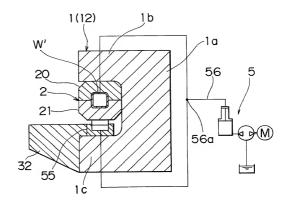
41a 42 43

32

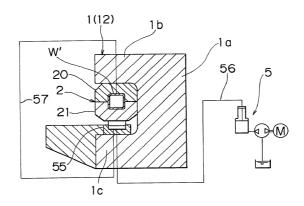
FIG. 29



F I G. 30



F I G. 31



F I G. 32

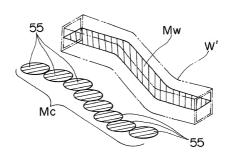


FIG. 33

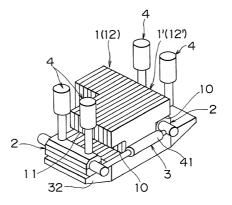
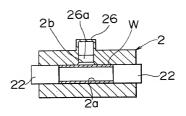


FIG. 34A



F I G. 34B

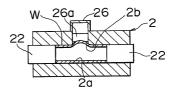
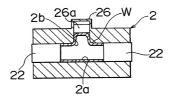
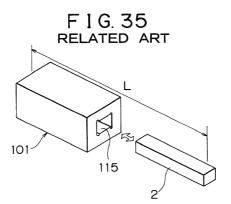
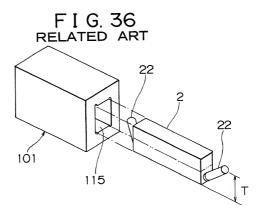
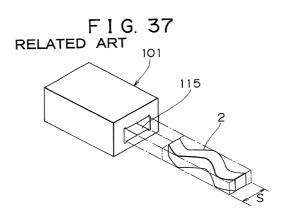


FIG. 34C









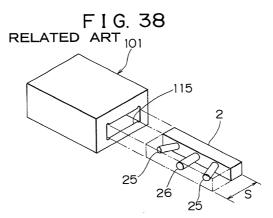


FIG. 39 RELATED ART

